

Work Order ID 55380

January 15, 2010 7:31:52 AM

Page 1

Item ID: D3763-041

Accept

Setup Start

Revision ID:

Stop

Item Name: End Fitting Assembly

Start Date: 1/15/10 Start Qty: 4.00

Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3763

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-make a 0.063" chamfer on D3763-1 fitting before ass'y! 2-assemble as per dwg D3763 using locating pin DT9039! *****ensure locating pin is in 0.221" hole***** 3-weld as per dwg D3763 QSI004 Alum. rod Batch: M111311

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control



10.01.15

4 *⊙*

10.01.15

4 *⊙*

10.01.15 *(4)*

Work Order ID 55380

January 15, 2010 7:31:52 AM

Page 2

Item ID: D3763-041

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

22 5/10/15

QC

Memo

0.00

(X)

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

SPN

HandFinish

Memo

0.00

10-01-15

(X)

Hand Finishing

150

QC3- Inspect Part Finish

0.00

0.00

m.f. 10/01/15

QC

Memo

Quality Control

(4X)

Work Order ID 55380

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Page 3

Item ID: D3763-041

Accept



Setup Start



Revision ID:

Stop



Item Name: End Fitting Assembly

Start Date: 1/15/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location 251A

0.00



Packaging

Memo

0.00

Packaging

10-1-15 (4x)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/18

MF
10-1-15

Picklist Print

January 15, 2010 7:31:51 AM

Page 1

Work Order ID: 55380



Parent Item: D3763-041



Parent Item Name: End Fitting Assembly

Start Date: 1/15/10

Required Date: 1/15/10

Comments: IPP Rev:A 08-05-20 new issue DD verified by:ec
 IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC
 IPP Rev:C 08-08-11 add chemical coat and qc3 DD verified by:EC

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3763-1		Manufactured	No			110	Each	17.0000	4.0000			
End Fitting												

10.01.15

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

54364

11

54433

6

D3763-3

Manufactured No

110

Each

0.0000

4.0000

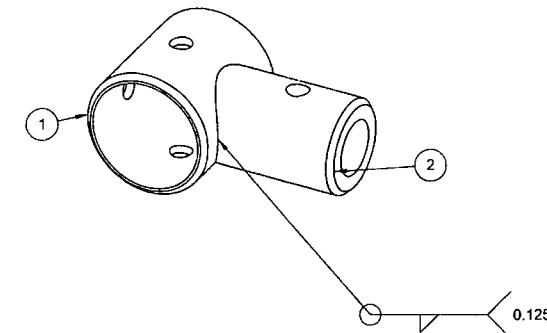
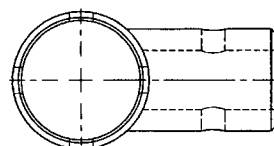
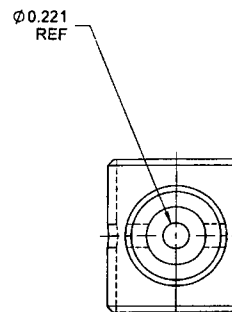
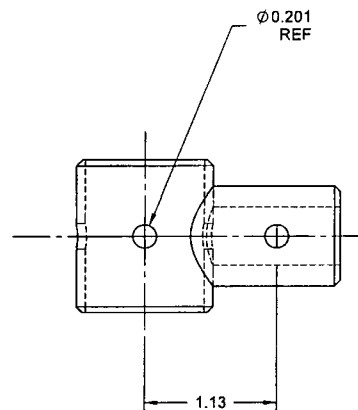


Tube

4

10.01.15

3 55344 = 4



W055380

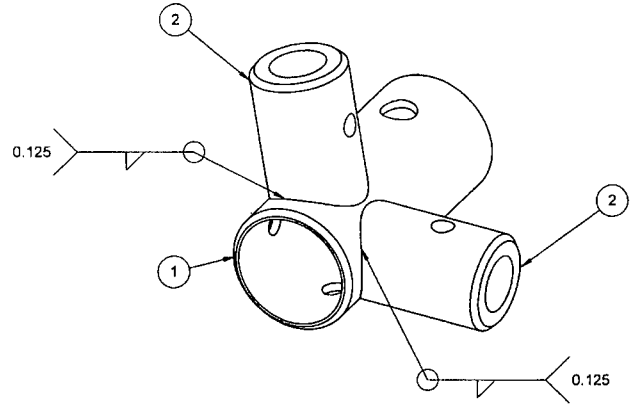
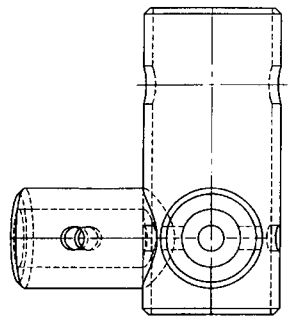
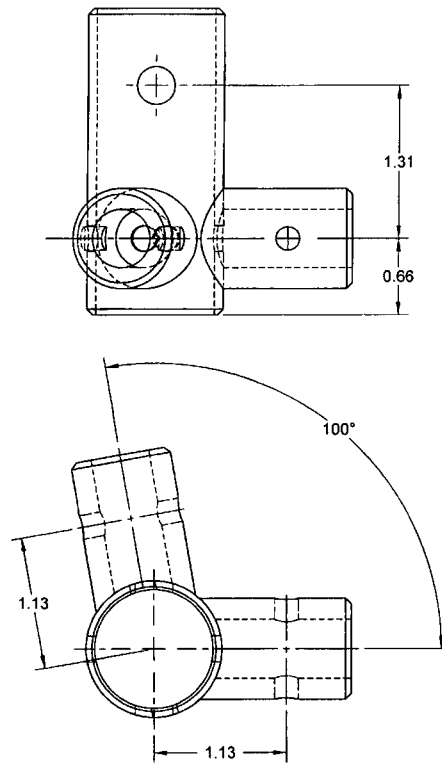
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

D3763-041 END FITTING ASSY

RELEASED
08.07.10

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs
 - 8) WELD: PER DART QSI 004

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	D3763	SHEET 1 OF 9
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	END FITTING	NTS
DE APPR.	<i>[Signature]</i>	DATE 08.06.23	
DATE		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	







ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2

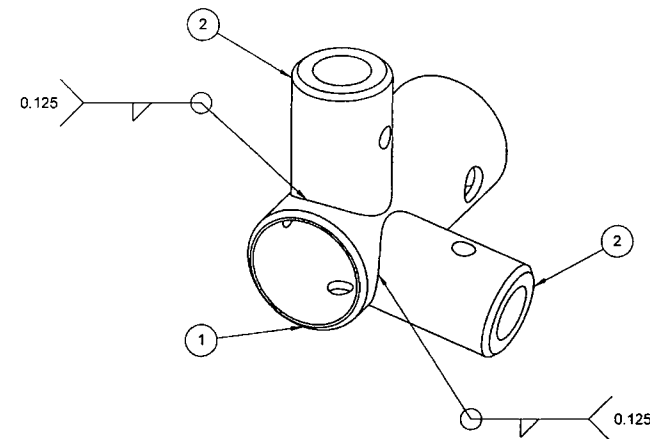
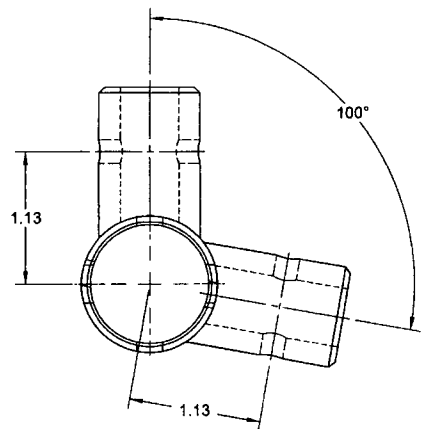
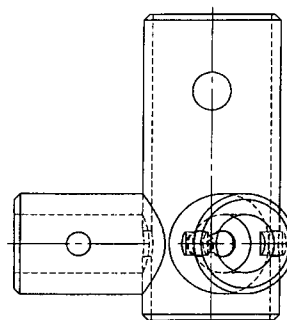
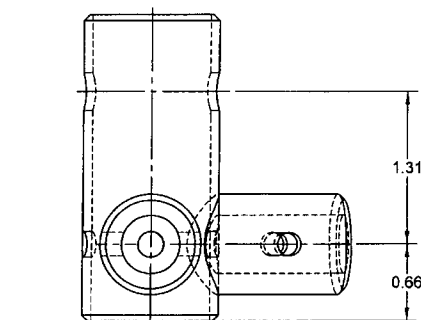
D3763-043 END FITTING ASSY, LH

W1055380

RELEASED
08-01-2014

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs
 - 8) WELD: PER DART QSI 004

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	NTS
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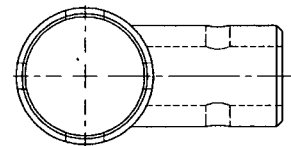
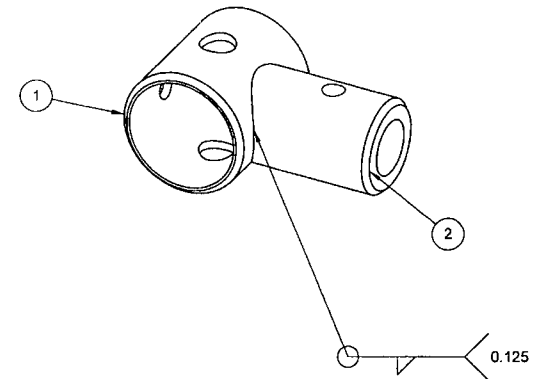
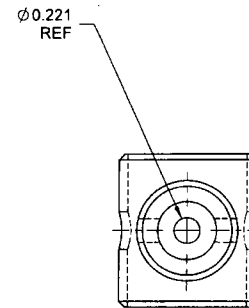
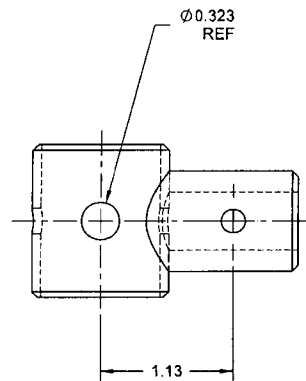
ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

D3763-044 END FITTING ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. D3763	REV. B
MFG. APPR.	HS	TITLE END FITTING	SHEET 3 OF 9
APPROVED	HS	SCALE NTS	
DE APPR.	HS	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-045)
1	D3763-7	TUBE	1
2	D3763-1	FITTING	1

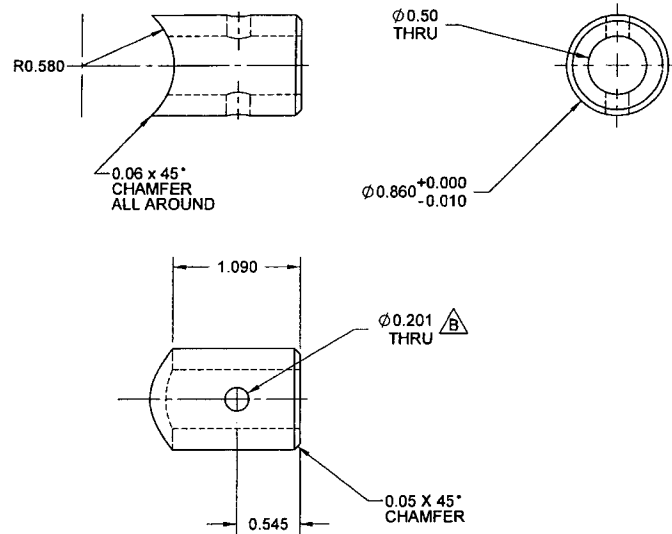
D3763-045 END FITTING ASSY

WLB 55380

RELEASED
08-07-10/11/12

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs
 - 8) WELD: PER DART QSI 004

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MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 9	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	END FITTING	NTS
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D3763-1 FITTING

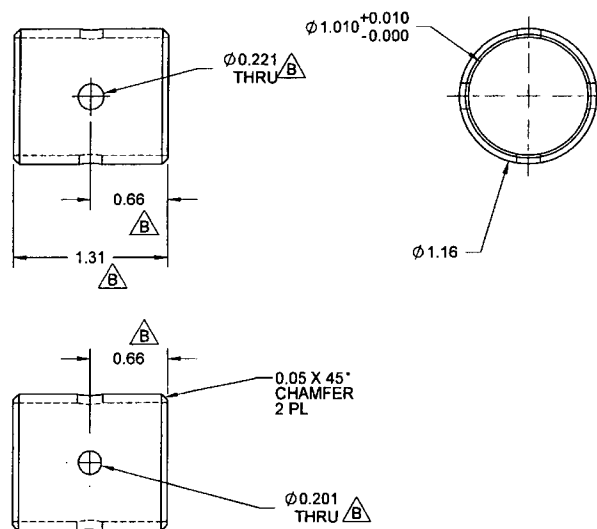
W1055380

RELEASED
108-07-10 TTP

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs





DESIGN	HS	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3763	SHEET 5 OF 9
APPROVED		TITLE	SCALE
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D3763-3 TUBE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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MFG. APPR.		D3763	SHEET 6 OF 9
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8

7

6

5

4

3

2

1

D

C

B

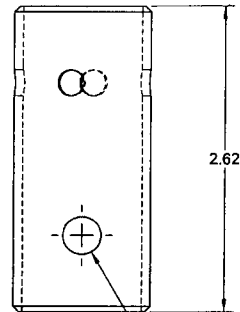
A

D

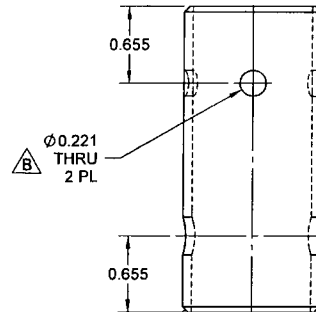
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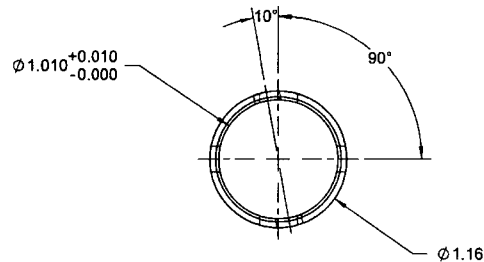
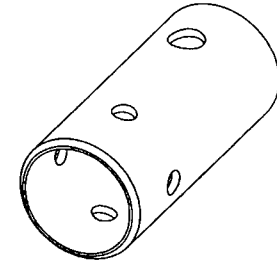


Ø0.323
THRU



Ø0.221
THRU
2 PL

0.05 X 45°
CHAMFER
2 PL



D3763-6 TUBE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 8061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4118) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO. D3763	REV. B
MFG. APPR.		TITLE	SHEET 8 OF 9
APPROVED		END FITTING	SCALE
DE APPR.			NTS
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8

7

6

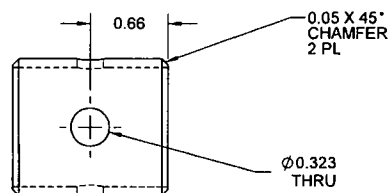
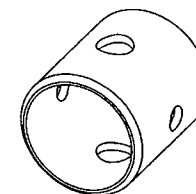
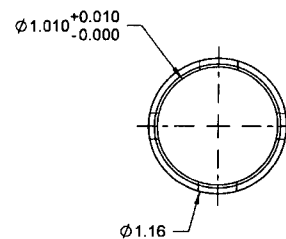
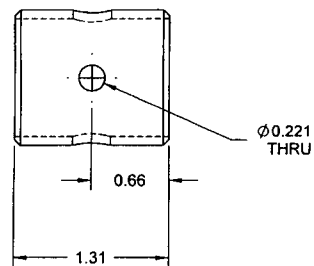
5

4

3

2

1



D3763-7 TUBE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO. D3763	REV. B
MFG. APPR.		TITLE	SCALE
APPROVED		END FITTING	NTS
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WU 55380

RELEASED
08.07.10